

# Work Order ID 82324

**\*82324\***

Page 1

March-28-12 4:02:04 PM

Item ID: D2665-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 28/03/2012 Start Qty: 4.00

**\*4\*** 10.0  
**\*4\***

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2665	Rev D

100	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*100*</b>									
HAAS 1									
HAAS CNC vertical machine #1	Memo	0.00							
	1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached								

110	CONVENTIONAL MILLING MACHINE	0.00							
<b>*110*</b>									
Mill Conv									
Conventional Milling Machine	Memo	0.00							
	Machine Keyway and inspect per attached dimension sheet								

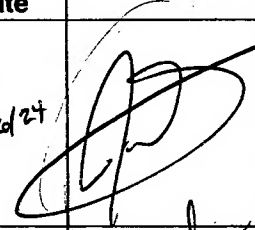
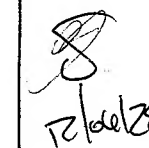
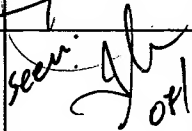
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC									
Quality Control	Memo	0.00							

W/O: 82324

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-2 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: Not Date: 11/07/10  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed: ck Date: 12/7/12

NCR: 12-1566		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/24	100	Cross tube bore (1.155") is too thin and other bore is fine, therefore I brought to the attention of programmer.	CP 12/6/25	SCRAP REPLACE.  Fix Program.	FK. 12/06/24		CP 12/6/25	 12/06/25
12/06/27	100				12/06/26	seen:  01/10/12		

NOTE: Date &amp; initial all entries

# Work Order ID 82324

March-28-12 4:02:04 PM

**\*82324\***

Page 2

Item ID: D2665-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop **\*NS2\***

Start Date: 28/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00		12-06-28					
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 11:30 OVEN TEMPERATURE:  
FINISH TIME: 11:50

3200 F

10 76 12-6-27

10X 12/07/03

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82324

March-28-12 4:02:04 PM

**\*82324\***

Page 3

Item ID: D2665-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft Out 206  
 Start Date: 28/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00				10	2	120/BL	12/07/03.
Quality Control									
170	Identify as per dwg & Stock Location: <u>436</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00				10			12/07/04 JB
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							12/7/5 JF
Quality Control									

MF  
12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-28-12 4:02:08 PM

Page 1

Work Order ID: 82324

\*82324\*

Parent Item: D2665-2

\*D2665-2\*

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C 00.11.01 Removed P/O for Powder Coat - in house process  
EC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	41.0000	1	4			
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\*D6101-003\*

Saddle Billet, 7075

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Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

78599

10

80765

0

MAT041

21

79587

4

80765

17

MAT042

-7

MAT044

1

73769

1

85434

11

FK 12/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82324
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140			0.119	0.119	0.120	0.120
B	0.100	0.140			0.100	0.102	0.104	0.104
C	1.125	1.145		1.142	1.138	1.127	1.140	1.131
D	0.615	0.685			0.685	0.685	0.685	0.685
E	0.240	0.260			0.250	0.260	0.257	0.260
F	1.313	1.343			1.321	1.321	1.333	1.330
G	0.210	0.230			0.219	0.218	0.227	0.223
H	0.100	0.180			0.140	0.140	0.130	0.135
I	2.470	2.510			2.491	2.492	2.492	2.492
J	1.565	1.585		1.577	1.578	1.567	1.580	1.571
K	0.235	0.240			0.238	0.238	0.238	0.238
L	0.100	0.120			0.118	0.118	0.114	0.113
M	0.990	1.010			1.003	1.003	1.003	1.003
N	0.510	0.515			0.512	0.512	0.512	0.512
O	5.990	6.010			6.000	6.000	6.000	6.000
P	1.245	1.255			1.250	1.250	1.250	1.250
Q	2.495	2.505			2.500	2.500	2.500	2.500
R	0.312	0.318			0.314	0.314	0.314	0.314
S	0.315	0.322			0.317	0.317	0.317	0.317
T	2.495	2.505			2.500	2.500	2.500	2.500
U	1.357	1.367			1.362	1.362	1.362	1.362
V	0.787	0.807			0.792	0.794	0.791	0.794
W	0.540	0.560			0.548	0.549	0.546	0.550
X	1.674	1.684			1.680	1.679	1.679	1.679
Y	0.256	0.262			0.258	0.258	0.258	0.258
Z	0.912	0.932			0.923	0.925	0.925	0.927
AA	0.490	0.510			0.497	0.499	0.501	0.500
AB	0.178	0.198			0.188	0.189	0.188	0.188
AC								
AD								
AE								
Accept/Reject				Scrap				

<b>Measured by:</b> PD/B	<b>Date:</b> 12/06/26
<b>Audited by:</b> SL	<b>Date:</b> 12-06-28
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b>	82324
<b>Description:</b> 206 Saddle, Outboard, Right side				<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1 6	2 7	3 8	4 9	5 10
A	0.100	0.140		0.120	0.120	0.120	0.119	0.118
B	0.100	0.140		0.106	0.106	0.105	0.105	0.105
C	1.125	1.145		1.134	1.136	1.139	1.135	1.135
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685
E	0.240	0.260		0.260	0.260	0.257	0.252	0.252
F	1.313	1.343		1.328	1.334	1.329	1.323	1.326
G	0.210	0.230		0.227	0.230	0.227	0.220	0.225
H	0.100	0.180		0.120	0.130	0.130	0.135	0.135
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.565	1.585		1.574	1.575	1.577	1.575	1.575
K	0.235	0.240		0.238	0.238	0.238	0.239	0.238
L	0.100	0.120		0.113	0.112	0.113	0.114	0.113
M	0.990	1.010		1.003	1.003	1.003	1.003	1.003
N	0.510	0.515		0.512	0.512	0.512	0.512	0.512
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		0.313	0.313	0.313	0.313	0.314
S	0.315	0.322		0.317	0.317	0.317	0.317	0.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		0.793	0.792	0.792	0.792	0.793
W	0.540	0.560		0.548	0.550	0.551	0.548	0.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.912	0.932		0.925	0.925	0.927	0.926	0.927
AA	0.490	0.510		0.501	0.495	0.502	0.500	0.500
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> PD / F.K.	<b>Date:</b>
<b>Audited by:</b> JL	<b>Date:</b> 12-06-28
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat, Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 82324
<b>Description:</b> 206 Saddle, Outboard, Right side				<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 <b>Rev:</b> D <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

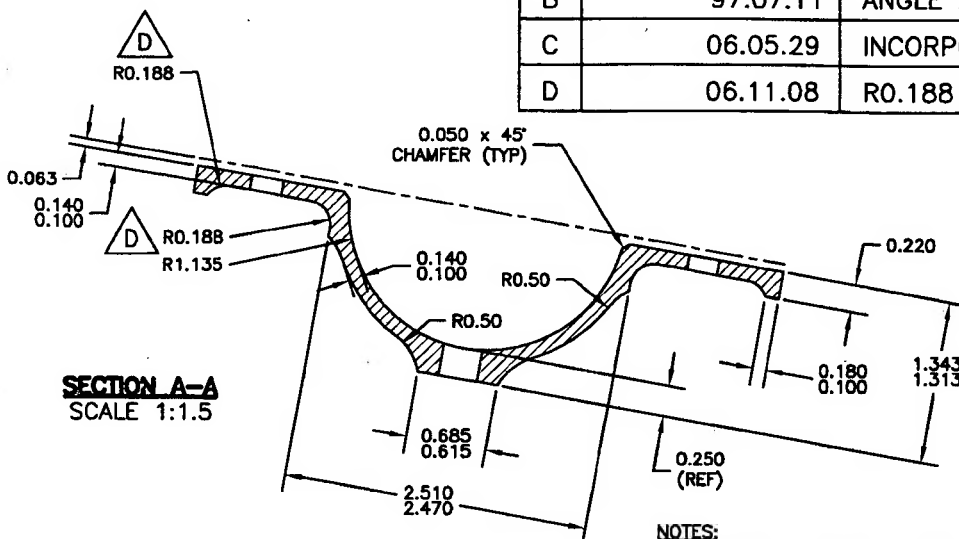
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	2	3	4	5
A	0.100	0.140		.120				
B	0.100	0.140		.105				
C	1.125	1.145		1.135				
D	0.615	0.685		.685				
E	0.240	0.260	.253	<del>1.228</del>				
F	1.313	1.343		1.328				
G	0.210	0.230		.225				
H	0.100	0.180		.135				
I	2.470	2.510		2.492				
J	1.565	1.585		1.575				
K	0.235	0.240		.237				
L	0.100	0.120		.114				
M	0.990	1.010		1.004				
N	0.510	0.515		.512				
O	5.990	6.010		6.006				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.312	0.318		.314				
S	0.315	0.322		.316				
T	2.495	2.505		2.500				
U	1.357	1.367		1.362				
V	0.787	0.807		.797				
W	0.540	0.560		.550				
X	1.674	1.684		1.679				
Y	0.256	0.262		.258				
Z	0.912	0.932		.925				
AA	0.490	0.510		.500				
AB	0.178	0.198		.188				
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> F.K.	<b>Date:</b> 12/06/28
<b>Audited by:</b> SL	<b>Date:</b> 12-06-28
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	



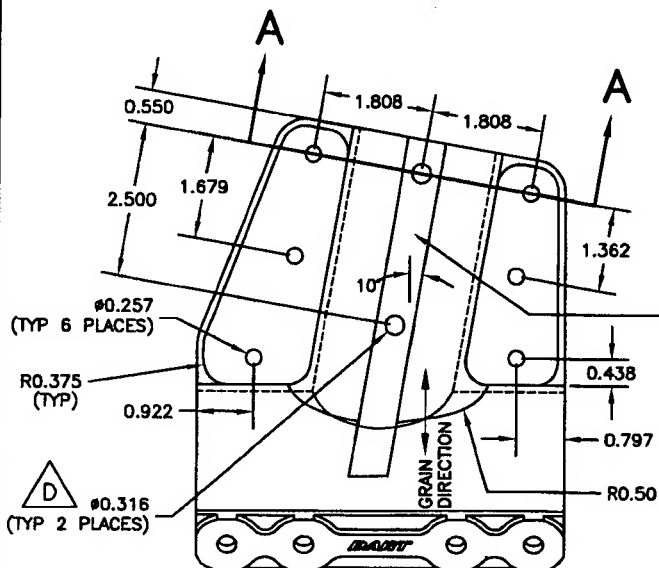
DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CB</i>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



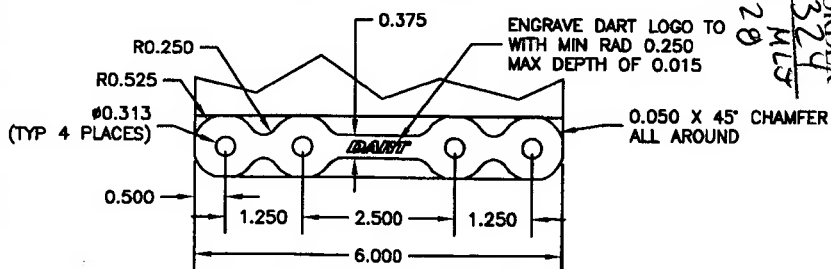
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07.02.12

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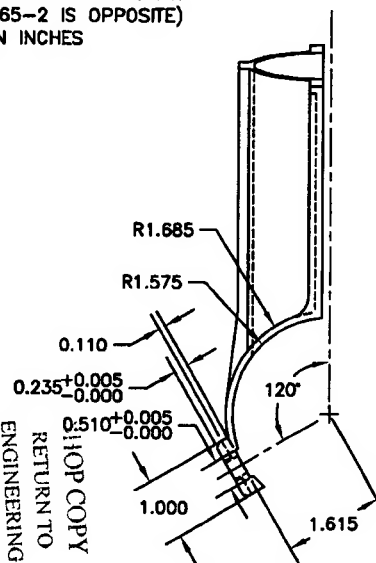
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



NO. 82324  
12/03/20  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
HOP COPY



**D2665-1 SADDLE FWD OUTSIDE HIGH**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries